

Date: Thursday, 5/4/2006 10:45:15 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE		
Job Number	: 27006 - 2				
Estimate Number	: 12403	Part Number	: D3511041		
P.O. Number	: N/A	Drawing Number	: D3511 REV A		
This Issue	: 5/4/2006	Project Number	: N/A		
Prsht Rev.	: NC	Drawing Revision	: A		
First Issue	: N/A	Material	: N/A		
Previous Run	: N/A	Due Date	: 5/5/2006	Qty:	2 Um; Each
Written By	: SEE COMMENT				
Checked & Approved By	: 06/05/04				
Comment	: Est Rev: A New Issue 06-05-04 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S188	304 SHEET .188" THICK
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Comment: Qty.: 1.5572 sf(s)/Unit Total : 12.4572 sf(s)
 304 SHEET .188" THICK
 (M304S0188)
 Batch: 1100473

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3511
 Dwg Rev: A
 Prog Rev: A

2-Deburr if necessary

06/05/04

(2)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/05/04

(2)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

06/05/04 (2)

5.0	D35031	CUP
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 64.0000 Each(s)
 CUP
 Batch: B27007

06/05/04 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 05/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 5/4/2006 10:45:16 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 27006

Part Number: D3511041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D3511

A/R SS ROD Batch: M100372

AA 06/05/04 (2)

7.0

QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

PD 06-05-05 (2)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3511

AD 06 05 04 (2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/05/05 (2)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

DL 06/05/05 (2)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

LD 6/5/05 (2)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A 6/5/05 (2)

13.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DD 06/05/05 (2)

Job Completion



N 06/05/05

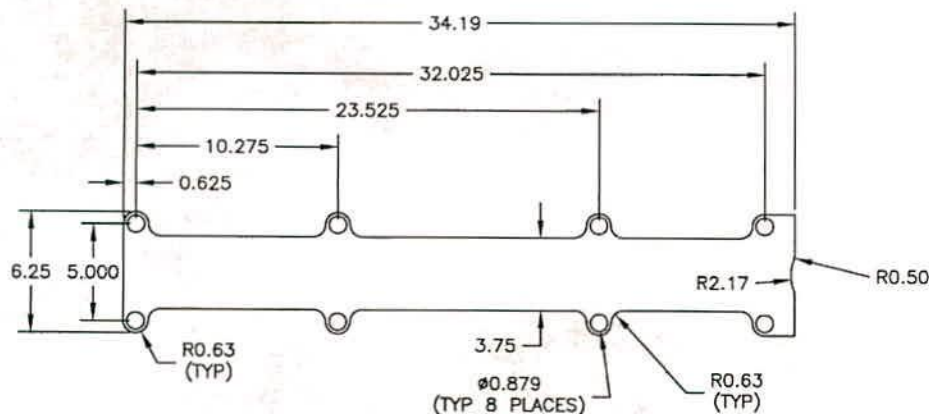
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

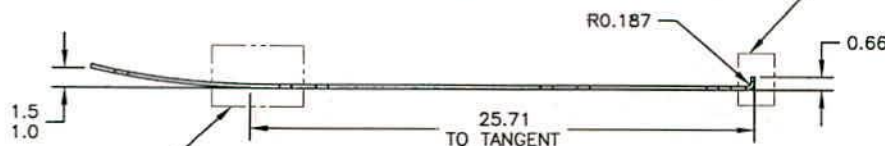
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



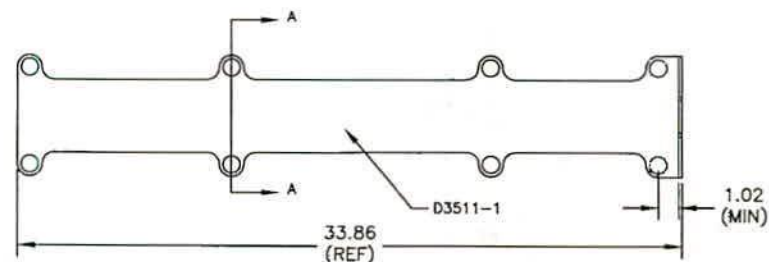
D3511-1F FLAT PATTERN

NOTE: BEND BEFORE WELDING



D3511-1 BEND DETAIL

NOTE: BEND AFTER WELDING



SECTION A-A

D3511-041 WELD DETAIL

D3511-041 WEARPLATE ASSEMBLY

- 1) MAKE D3511-1F WEARPLATE FROM: AISI 304/316 STAINLESS STEEL (0.188 THICK)
(REF DART MATERIAL SPEC. M304S7GA)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ASSEMBLY BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.015

D3511-041 WEARPLATE ASSEMBLY PARTS LIST

QTY -041	PART NUMBER	DESCRIPTION
X	D3511-041	WEARPLATE ASSEMBLY
1	D3511-1	WEARPLATE
8	D3503-1	CUP

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 27006

RELEASED

76 04 25

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A	06.04.04	NEW ISSUE
DESIGN	PH	DART
DRAWN BY	PH	DART AEROSPACE LTD. MISSISSAUGA, ONTARIO, CANADA
CHECKED	PH	DRAWING NO. D3511
DATE	06.04.04	TITLE WEARPLATE
		REV. A SHEET 1 OF 1 SCALE NTS

